

# Work Order ID 71812

Tuesday, July 12, 2011 12:06:53 PM



Page 1

Item ID: D4018-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Lid Assembly (350 )

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*MWF*

Date: 11-07-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4018

C

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *M115278*

0.00

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4018 using DT9607B

2- weld hinge (3) and Mounting brackets as per dwg D4018

\*\*\*inspect before welding mesh\*\*\*

3- tack weld mesh on basket as per dwg D4018

\*\*\*make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

*11.07.19*

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*11.07.19*

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Revision ID:					Stop	
Item Name:	Short Basket Lid Assembly (350 )					
Start Date:	7/12/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/22/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							
130 	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat Powder Coating	Memo *** mask sides of hinge prior to powdercoat*** Start Time: 8:15 Oven Temperature: 300° Finish Time: 3:45	0.00							1 φ BL 11-7-19
140 	Wing Walk as per dwg QSI005 4.4 Batch M11786000								
HandFinish Hand Finishing	Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- install label	0.00							1 φ M 11/07/20

**Work Order ID 71812**

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Item ID: D4018-041

Accept



Setup Start



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Stop



Item Name: Short Basket Lid Assembly (350 )

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

E511/07/20 @

160



Identify as per dwg &amp; Stock Location:

G.A

0.00

Packaging

Memo

0.00

Packaging

w/o  
71809

E511/07/20 @

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/7/20 @

ME  
11-07-20

# Picklist Print

Tuesday, July 12, 2011 12:06:50 PM

Page 1

Work Order ID: 71812

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )



Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
DD 10.04.16 verified by:EC  
verified by:EC  
IPP Rev:B as  
IPP Rev:C as per dwg RevB  
IPP Rev:D as per dwg revC DD 10.08.18

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4018-1  Rib		Manufactured	No			100	Each	4.0000	2	2		11.07.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				67039		2							
				WA005		2							
				69077		2							
D4018-3  Rib		Manufactured	No			100	Each	10.0000	2	2		11.07.15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		10							
				63128		4							
				68479		6							
D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	10.0000	3	3		11.07.18	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				69164		4							
				70373		6							
				11941		2							

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 12:06:50 PM

Work Order ID: 71812

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5 Manufactured No

100 Each 29.0000 6 6



Rib

870758

⑥



11.07.15

Location

Loc Qty

Loc Code

WA

15

69163

15

WA005

14

67041

14

D4035-041 Manufactured No

100 Each 3.0000 1 1



Lid Rib Assembly, Fwd (350 Basket)

71484

⑦



11.07.15

Location

Loc Qty

Loc Code

WA006

3

69727

3

D4035-043 Manufactured No

100 Each 2.0000 1 1



Lid Rib Assembly, Aft (350 Basket)

71485

⑦



11.07.15

Location

Loc Qty

Loc Code

WA

2

69869

2

D2581 Manufactured No

100 Each 83.0000 2 2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

83

69258

28

69739

4

70766

51



11.07.15

②

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 12:06:51 PM

Page 3

Work Order ID: 71812

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D4020-7

Manufactured No

100 Each

1.0000

1

1



Mesh (350 Basket Short, Lid)

B72006

①



11.07.19

Location

Loc Qty

Loc Code

FG

1

68523

1

D4021-3

Manufactured No

100 Each

4.0000

1

1



Data Plate



11.07.15

Location

Loc Qty

Loc Code

WA005

4

70240

4

D2728-3

Manufactured No

140 Each

0.0000

1

1



Dart Logo label

1115050



(x1) 11/07/20

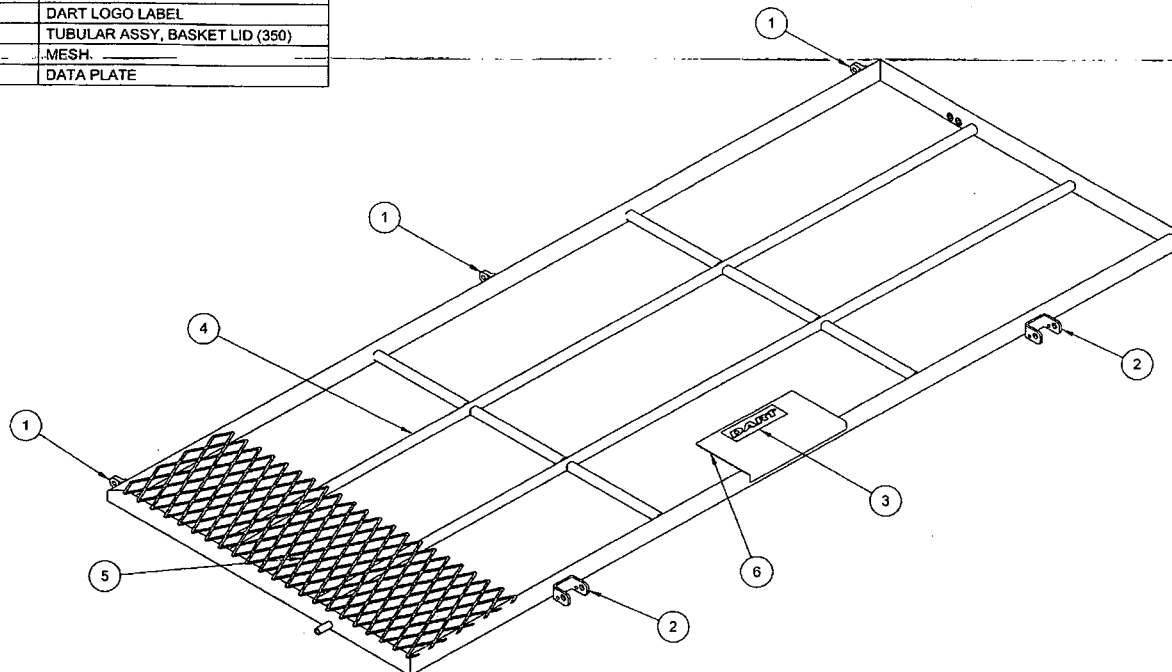
Tuesday, July 12, 2011 12:06:51 PM

Shop Packet Print

Page 3



ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.08.05  
ECN 10-916

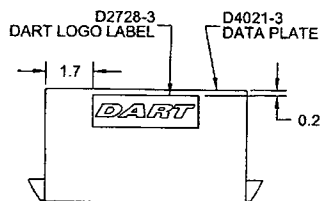
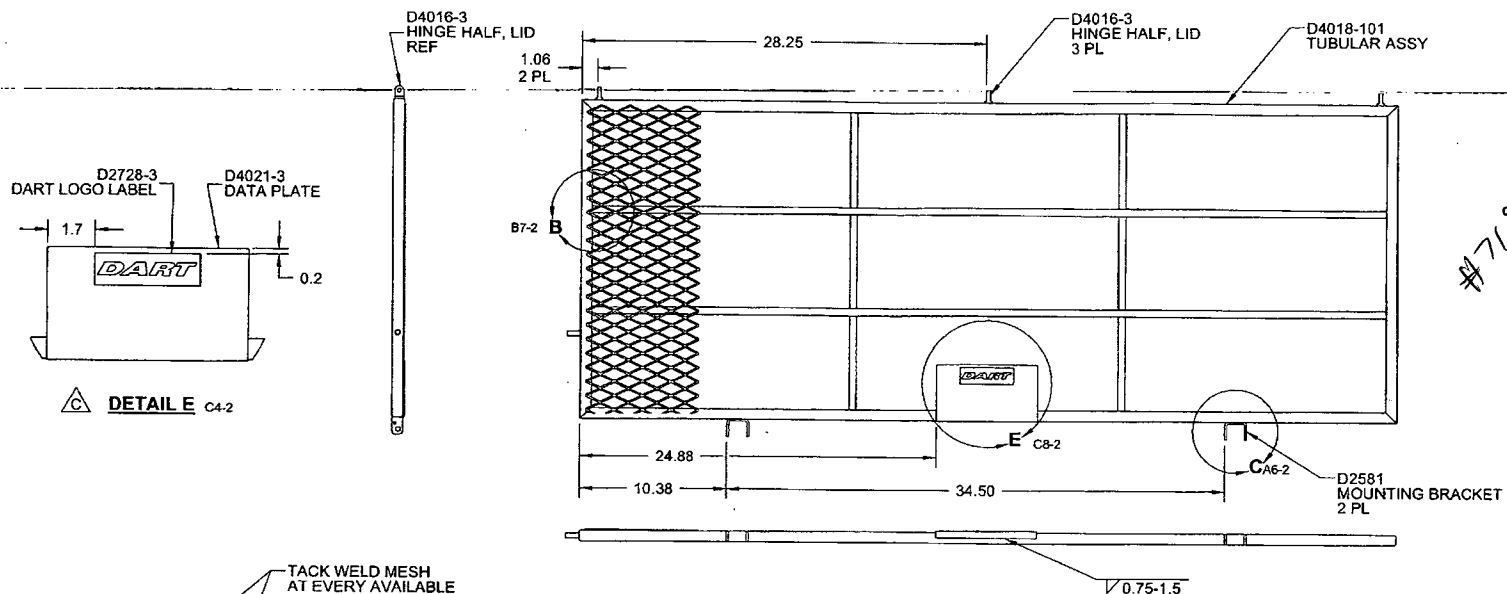
C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	MD		
DE APPR.			
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

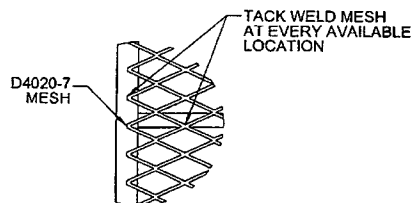
DRAWING NO. **D4018** REV. C  
SHEET 1 OF 4

TITLE **SHORT BASKET LID ASSY (350)** NTS  
SCALE

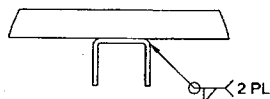
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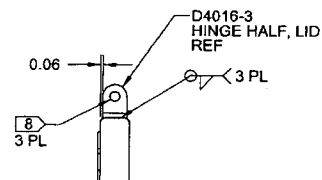
DETAIL E C4-2



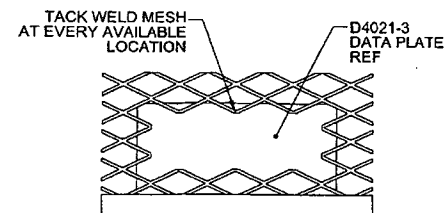
DETAIL B C8-2



DETAIL C C3-2



DETAIL D D1-2



VIEW A-A C1-2

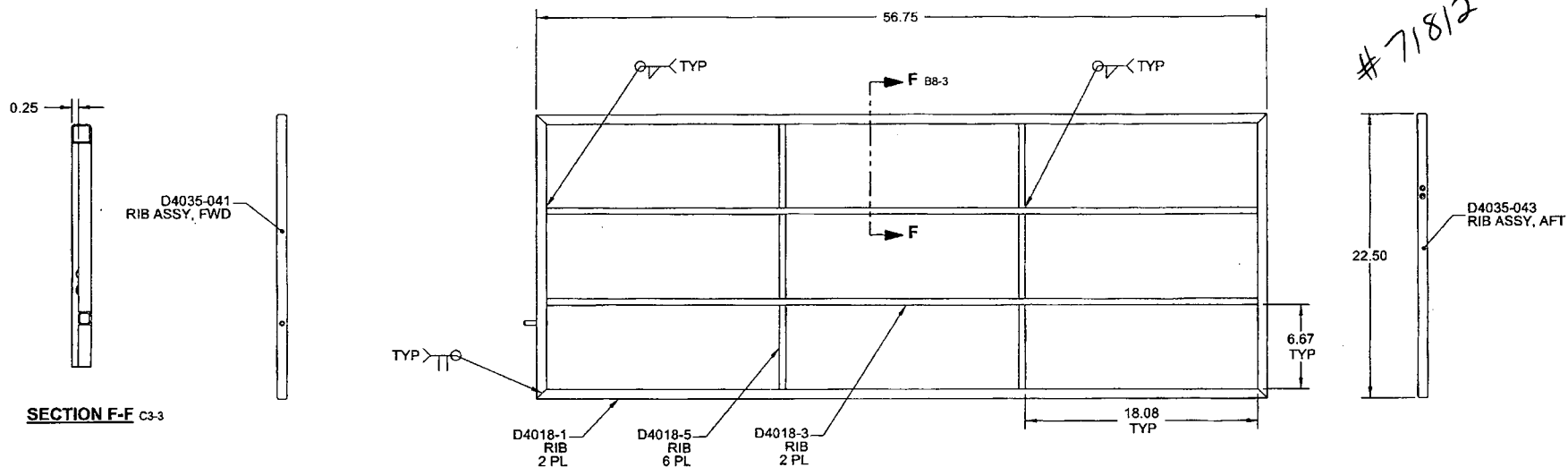
RELEASED  
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AS	D4018	SHEET 2 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SHORT BASKET LID ASSY (350) NTS	
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION F-F C3-3

8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED  
10.08.05

NOTES:

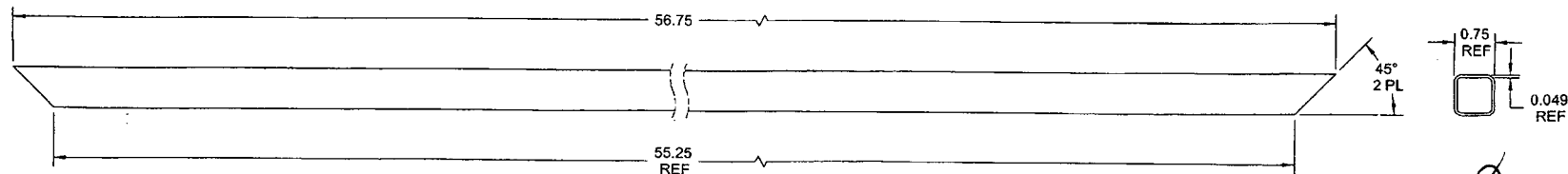
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101,
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	sc	DRAWING NO.	REV. C
MFG. APPR.	W	D4018	SHEET 3 OF 4
APPROVED	W	TITLE	SCALE
DE APPR.	W	SHORT BASKET LID ASSY (350) NTS	
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8 7 6 5 4 3 2 1

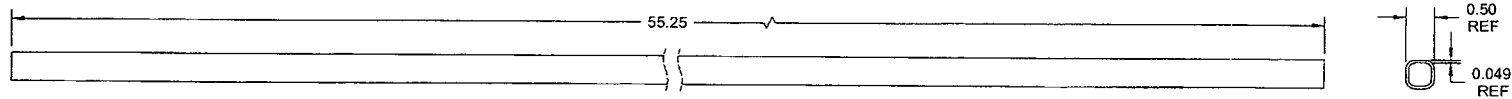
D

D

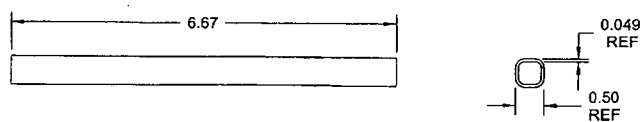


**D4018-1 RIB**

#71810



**D4018-3 RIB**



**D4018-5 RIB**

RELEASED  
10.08.05

**NOTES:**

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	A/S	<b>DART AEROSPACE LTD</b>	
DRAWN	S	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ISC	DRAWING NO. D4018	REV. C
MFG. APPR.	ISC	SHEET 4 OF 4	
APPROVED	ISC	TITLE	SCALE
DE APPR.	ISC	SHORT BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1

A

A